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D350-636-011
Job Sheet 181319



Part No: D350-636-011

Job Qty: 1 ea

Part Name: Skidtube LH, Std Wearplates, DART (Apical) Cylindrical/Aerazur Float Comp.



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 7/25/18

Job Tracking No:

Due Date: 8/22/18

Created By: Marie Lajeunesse

Type: Stock

Description:

Note: D2750-041 REV G SHEETS 1,2,4,8 IPP Rev:I 02.09.25 IPP Rev:J 06-03-23 As per Rev D IPP Rev:K 06-07.13
As per dsI9343 IPP Rev:L 07-07-28 Added SS Wearplates(Rev E) JLM Verf:EC IPP Rev:M 08-04-22 DD
verified:EC IPP Rev:N 08-09-23 revF DD verified:ec IPP Rev:O 09-02-06 per PAR09-010 DD verf:EC IPP
Rev:P 10.06.22 revise seq110 DD verf:EC IPP Rev:Q 10.10.01 as per IIN revH DDverf:EC IPP REV:R
13.08.27 PER ECN13-594 DD VERF:JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	1 Ea	8/22/18	8/22/18	0.00	0.00	Start Up Skidtubes-1		MCG
110	Skidtubes	1 pcs	8/22/18	8/22/18	0.00	4.55	Skidtubes-4		MCG DAS
120	QC	1 pcs	8/22/18	8/22/18	0.00	0.00	QC10		38 9-89 38
130	QC	1 pcs	8/22/18	8/22/18	0.00	0.00	QC5		DR 18-08-15
140	HandFinish	1 pcs	8/22/18	8/22/18	0.00	0.93	HandFinish1		BE
150	QC	1 pcs	8/22/18	8/22/18	0.00	0.00	QC7-2		BE
160	Skidtubes	1 pcs	8/22/18	8/22/18	0.00	4.55	Skidtubes-4		PD 13 08 21
170	QC	1 pcs	8/22/18	8/22/18	0.00	0.00	QC10		AK 18-8-21
180	QC	1 pcs	8/22/18	8/22/18	0.00	0.00	QC5		AK 18-8-21
190	HandFinish	1 pcs	8/22/18	8/22/18	0.00	0.93	HandFinish2		AK 18-8-21
200	SprayPaint	1 pcs	8/22/18	8/22/18	0.00	0.91	Spray Paint		PO 40812
205	Outsource	1 pcs	8/22/18	8/22/18			ATE003-VC	AUG 2 2 2018	BER 18-08-23
210	QC	1 pcs	8/22/18	8/22/18	0.00	0.00	QC14		BER 18-08-23
230	HandFinish	1 pcs	8/22/18	8/22/18	0.00	0.93	HandFinish4		BER 18-08-23
240	QC	1 pcs	8/22/18	8/22/18	0.00	0.00	QC5		AUG 2 7 2018 68
250	Packaging	1 pcs	8/22/18	8/22/18	0.00	0.00	Packaging1-3		AUG 2 7 2018 9-89
260	QC	1 pcs	8/22/18	8/22/18	0.00	0.00	QC4		21 8-89 21
270	Packaging	1 pcs	8/22/18	8/22/18	0.00	0.00	Packaging3-1		21 8-89 21
275	DC	1 pcs	8/22/18	8/22/18	0.00	0.00	DC		21 8-89 21
280	QC21-FG	1 Ea	8/22/18	8/22/18	0.00	0.00	QC21		21 AUG 2 7 2018

Part Op 110 - 1- Pick D2600-3 Bent 2- Deburr FWD and AFT ends, remove bending marks. Scribe batch# inside AFT end per dwg
Descriptions: D2750-1 3- Drill pilot holes for blade fitting bolt holes using DT8983. Start with 3/16", then open to 0.500" using center drill
then ream holes using 0.500" reamer. P/N first side. Repeat process on second side. ***ENSURE PROPER
POSITIONING FWD BEND MUST BE FACING UP WHEN DRILLING FIRST SIDE*** Drill pilot holes as per Dwg D2750
sheet 4 (D2750-1 details). Drill using drill Jig DT8150 & DT8863A for 2nd side only DT8863B for first side (detail B) 4-
Locate DT8330 off of blade fitting bolt holes and drill pilot holes for blade fitting. Open to 0.500" using hole saw. VERIFY
AND RECORD FWD BEND ANGLE. 5-Drill pilot holes for wearplates as per Dwg D2750 using DT8108 open to 0.297".
6-Open up holes of Detail A to 0.297" (total of 2 holes per side) 7-Weld D2744 Cap as per Dwg D2750 and QSI 004.Fill
grooves in bend left from bending as per QSI 004 A/R Aluminum Rod batch: 138834 8-Grind welds flush as per Dwg
D2750
160 - 1-Open up holes using hole saw of Detail C and ground handling to 0.625" (total of 8 holes per side) as per dwg

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____		DISPOSITION		AGAINST DEPARTMENT/PROCESS			
Part No. _____		Rework ☐		Skid-tube Machining ☐	Cross tube Small Fab ☐	Water Jet ☐	Engineering Quality Other ☐
NCR No. _____		Suspected		Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐			
Date : _____		Step #: _____		042) Approval ☐			
Description Work Order Deviation							
1270 Aberdeen Street Newtebury, ON K6A 1K7 CANADA TEL: 1 813 832-6200 Email: sales@dartaero.com www.dartaerospace.com DART AEROSPACE Container No: S100737 Part: D350-636-011 Job No: 181319 Serial No/Batch: S100737 Revision: _____ Inspector: _____ Exp Date: _____ Instructions: TC STC SH99-7 Issue 2, EA-687A SR00646SE 15/10/28, EASA STC							
nd / Supervisor val Verification							
QA Coordinator Approval							
sitioned Wrong outside Dimensions ver/Under tolerance							
Part Incorrect Part Lost/Missing Part Moved Drawing Finish Misread Turning Sequence							
Root Cause							
Environment ☐	No Re-verification ☐	Pressure ☐	Set-up ☐	Crack ☐	Weld ☐	Part Incorrect ☐	
Design ☐	Operator ☐	Bending ☐	BOM/Route ☐	Broken/Damage/Defect ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐	
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	Inspection Incomplete/Unqualified ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐	
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Countersink ☐	Off-set ☐	Mislabeled ☐	Drawing ☐	
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Cut Too Short ☐	Fit/Function ☐	Misaligned/off center ☐	Finish ☐	
Material ☐	Use for Testing ☐	Cuffs ☐	Instructions Incomplete/Unclear ☐	Drill Holes ☐		Misread ☐	
Internal Transport ☐	Poor Information ☐	Crushing ☐				Turning Sequence ☐	
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐					
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐					
Substation ☐	Process Improvement ☐	Marks/Chatter ☐					
Past Expiry Date ☐	Manufacturing Process ☐						
Misidentified ☐	Past Due ☐	OTHER : _____					

D2750. 2-Open up holes using hole saw of Detail B to 0.750" (total of 4 holes per side) as per dwg D2750. 3- Open float hole using un-bit to 0.500" (4 per side) 4-Chamfer holes of Detail B, C, ground handling and float holes per dwg D2750 (welding instructions on sheet 8) 5-Deburr and blow out all chips from inside of tube 6- Prepare tube for welding, remove alodine as required. 7-Bond web D2739 in place as per QSI 015, let cure for 12hrs. A/R Sikaflex-291 batch: 138874 exp. date: 4-9-08 ***ATTN: USE I-BEAM LOCATION AID (BLADE FITTING)*** 8- Weld spacers D3490-1, D3490-3 and D2743 as per dwg D2750 & QSI004 (welding instructions on sheet 8) A/R Aluminum Rod batch: 128834 9- At section AJ-AJ drill out x-bolt spacer to 0.404" 10-Grind welds flush as per Dwg D2750 11-Spot face ground handling holes section (total of 4 places per side) as per dwg D2750 12-Deburr holes, ensure tube is free of all scratches before sending to paint.

180 - ***VERIFY C'BOARD IS GOOD***

190 - Re-alodine tube as per QSI 005 section 4.1.2.1 do not acid etch.

200 - 1- PRIME AS PER DWG AND QSI 005 4.2 PRIMER PRC DESOTO 515X349 BATCH: _____ 2- PAINT WHITE AS PER DWG AND QSI 005 4.2 PAINT BATCH: _____

210 - Inspect for foreign object per QSI 024

230 - 1- Install inserts as per Dwg D2750 2-Inspect for Foreign Objects 3- Install blade fitting D3488-041, wearshoes and ground handling hardware as per dwg D2750 SIKA FLEX 241 BATCH: M138874 EXP DATE: 06/19 4- Assemble o'ring to plug as per dwg D3492 and apply o'ring lube A/R 55-o'ring lube batch: M138843 5- Coat all exposed fasteners with "LPS Procyon" batch: M137690

260 - *****ensure antiseize is on AN8C21A bolts*****

270 - Package as per PPP D350-636-011 Location : FG072

275 - record fwd angle: 90 Photocopy blue file and type labels per PPP D350-636-011 CHG 007

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D2600-3-BENT-LH	Extrusion Bent LH	1 Ea (1 ea)	90-Start up Operation	<u>S082013</u>
D2744	Cap	1 Ea (1 ea)	110-Skiddtubes	<u>S060499</u>
D2739	350 I-Beam	1 Ea (1 ea)	160-Skiddtubes	<u>S081781</u>
D2743	Crossbolt Spacer	8 Ea (8 ea)	160-Skiddtubes	<u>S090612</u>
D3490-1	Cross Bolt Spacer	4 Ea (4 ea)	160-Skiddtubes	<u>S082748</u>
D3490-3	Cross Bolt Spacer	4 Ea (4 ea)	160-Skiddtubes	<u>S082950</u>
AN3C5A	Bolt	34 Ea (34 ea)	230-HandFinish	<u>S095214</u>
AN3C6A	Bolt	4 Ea (4 ea)	230-HandFinish	<u>S076000</u>
AN6C44A	Bolt	4 Ea (4 ea)	230-HandFinish	<u>S006333-1</u>
AN8C35A	Bolt	1 Ea (1 ea)	230-HandFinish	<u>FM137203</u>
D2745	Bushing	8 Ea (8 ea)	230-HandFinish	<u>S091818</u>
D3488-041	Blade Fitting LH	1 Ea (1 ea)	230-HandFinish	<u>S092787</u>
D3492-1	Plug	8 Ea (8 ea)	230-HandFinish	<u>S077552</u>
D3492-3	Plug	8 Ea (8 ea)	230-HandFinish	<u>S091848</u>
D3535-25	Wearplate Center	1 Ea (1 ea)	230-HandFinish	<u>S082036</u>
D3536-25	Gasket Center	1 Ea (1 ea)	230-HandFinish	<u>S081731</u>
D3537-1	Wearpad	3 Ea (3 ea)	230-HandFinish	<u>S053117</u>
D3631-1	Washer	8 Ea (8 ea)	230-HandFinish	<u>S058407</u>
D3791-1	Wearpad	1 Ea (1 ea)	230-HandFinish	<u>S071379</u>
D3793-1	Wearplate Fwd	1 Ea (1 ea)	230-HandFinish	<u>S089345</u>
D3793-3	Wearplate Aft	1 Ea (1 ea)	230-HandFinish	<u>S089448</u>
D3794-1	Gasket Fwd	1 Ea (1 ea)	230-HandFinish	<u>S071975</u>
D3794-3	Gasket Aft	1 Ea (1 ea)	230-HandFinish	<u>S081738</u>
MS21043-6	Nut	4 Ea (4 ea)	230-HandFinish	<u>S083545</u>
MS21083C8	Nut	1 Ea (1 ea)	230-HandFinish	<u>S050046-1</u>
NAS1149C0332R	Washer	38 Ea (38 ea)	230-HandFinish	<u>S071663</u>
NAS1149C0832R	Washer	1 Ea (1 ea)	230-HandFinish	<u>M138409-124</u>
NAS1515H3L	Washer	4 Ea (4 ea)	230-HandFinish	<u>S036714</u>
NAS1611-010	O-Ring	8 Ea (8 ea)	230-HandFinish	<u>S092499</u>
NAS1611-013	O-Ring	8 Ea (8 ea)	230-HandFinish	<u>S083560</u>
ALS4-1032-225	Rivnut	38 Ea (38 ea)	230-HandFinish	<u>S058138</u>
AN8C21A	Bolt	2 Ea (2 ea)	250-Packaging	<u>FH134102</u>
D2741	Replacement Blade	1 Ea (1 ea)	250-Packaging	<u>S082286</u>
D3493-1	Washer	2 Ea (2 ea)	250-Packaging	<u>S085455</u>
D3532-1	Spacer	2 Ea (2 ea)	250-Packaging	<u>S090421</u>
MS21083C8	Nut	2 Ea (2 ea)	250-Packaging	<u>S083557</u>
NAS1149D0863J	Washer	2 Ea (2 ea)	250-Packaging	<u>S089288</u>

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
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DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td style="width:15%;">Skid-tube ☐</td> <td style="width:15%;">Cross tube ☐</td> <td style="width:15%;">Water Jet ☐</td> <td style="width:15%;">Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>						Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐																						
Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐																						
Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐																						
Large Fab ☐	Composite ☐	Supplier ☐																							
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval																		
Description Work Order Deviation				Disposition				Completed By																	
								Lead hand / Supervisor Approval Verification																	
								QC / QA Coordinator Approval																	
Root Cause		FAULT CATEGORY																							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐																				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐																				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐																				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐																				
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Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐																				
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐																				
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐																				
Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____																							
Misidentified ☐	Past Due ☐																								

90-Start up Operation	D2600-3-BENT-LH	1	13	0
110-Skidtubes	D2744	1	57	0
160-Skidtubes	D2739	1	27	0
	D2743	8	207	0
	D3490-1	4	167	0
	D3490-3	4	90	0
230-HandFinish	ALS4-1032-225	38	3,719	0
	AN3C5A	34	3,009	0
	AN3C6A	4	336	0
	AN6C44A	4	235	0
	AN8C35A	1	44	0
	D2745	8	285	0
	D3488-041	1	17	0
	D3492-1	8	224	0
	D3492-3	8	269	0
	D3535-25	1	29	0
	D3536-25	1	26	0
	D3537-1	3	160	0
	D3631-1	8	707	0
	D3791-1	1	25	0
	D3793-1	1	35	0
	D3793-3	1	52	0
	D3794-1	1	37	0
	D3794-3	1	31	0
	MS21043-6	4	292	0
	MS21083C8	1	156	0
	NAS1149C0332R	38	5,579	0
	NAS1149C0832R	1	426	0
	NAS1515H3L	4	587	0
	NAS1611-010	8	625	0
	NAS1611-013	8	1,215	0
250-Packaging	AN8C21A	2	106	0
	D2741	1	105	0
	D3493-1	2	71	0
	D3532-1	2	94	0
	MS21083C8	2	156	0
	NAS1149D0863J	2	161	0

Part Specifications

Specifications could not be found.

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval 		
Description Work Order Deviation				Disposition					
				Completed By					
				Lead hand / Supervisor Approval Verification					
				QC / QA Coordinator Approval					

Root Cause				FAULT CATEGORY			
Environment	☐	No Re-verification	☐	Pressure/Forced	☐	Temperature/Cure	☐
Design	☐	Operator	☐	Bending	☐	Set-up	☐
Doc/Data	☐	Offset/Setup	☐	Centre Not Concentric	☐	BOM/Route	☐
Equip/Tooling	☐	Supplier	☐	Cracks	☐	Broken/Damage/Defect	☐
Handling/Pre	☐	Training	☐	Crimp/Kink/Ripple/Wave	☐	Inspection Incomplete/Unqualified	☐
Material	☐	Use for Testing	☐	Cuffs	☐	Contamination	☐
Internal Transport	☐	Poor Information	☐	Crushing	☐	Countersink	☐
Tribal Knowledge	☐	Rushing	☐	Heat Treat	☐	Cut Too Short	☐
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Substation	☐	Process Improvement	☐	Marks/Chatter	☐	Drill Holes	☐
Past Expiry Date	☐	Manufacturing Process	☐	OTHER : _____			
Misidentified	☐	Past Due	☐				

QTY -041	QTY -042	QTY -043	QTY -044	PART NUMBER	DESCRIPTION
X				D2750-041	350 SKIDTUBE ASSEMBLY, LH
	X			D2750-042	350 SKIDTUBE ASSEMBLY, RH
		X		D2750-043	350 SKIDTUBE ASSEMBLY, LH
			X	D2750-044	350 SKIDTUBE ASSEMBLY, RH
1	1	1	1	D2739	WEB
8	8	8	8	D2743	SPACER
1	1	1	1	D2744	CAP
8	8	8	8	D2745	BUSHING
1				D2750-1	SKIDTUBE WELDMENT, LH
	1			D2750-2	SKIDTUBE WELDMENT, RH
		1		D2750-3	SKIDTUBE WELDMENT, LH
			1	D2750-4	SKIDTUBE WELDMENT, RH
1		1		D3488-041	BLADE FITTING, LH
	1		1	D3488-042	BLADE FITTING, RH
4	4	4	4	D3490-1	SPACER
4	4			D3490-3	SPACER
		4	4	D3490-5	SPACER
8	8	8	8	D3492-041	PLUG ASSEMBLY
8	8			D3492-043	PLUG ASSEMBLY
		8	8	D3492-045	PLUG ASSEMBLY
1	1	1	1	D3535-25	WEARSHOE
1	1	1	1	D3536-25	GASKET
3	3	3	3	D3537-1	WEARPAD
8	8	8	8	D3631-1	WASHER
1	1	1	1	D3791-1	WEARPLATE
1	1	1	1	D3793-1	WEARSHOE
1	1	1	1	D3793-3	WEARSHOE
1	1	1	1	D3794-1	GASKET
1	1	1	1	D3794-3	GASKET
38	38	38	38	ALS4-1032-225	INSERT (OR ALS7-1032-225, AKS4-1032-225, AELS-1032-225)
34	34	34	34	AN3C5A	BOLT
4	4	4	4	AN3C6A	BOLT
4	4	4	4	AN6C44A	BOLT
1	1	1	1	AN8C35A	BOLT
38	38	38	38	AN960C10L	WASHER
1	1	1	1	AN960C816L	WASHER
4	4	4	4	MS21043-6	NUT
1	1	1	1	MS21083C8	NUT
4	4	4	4	NAS1515H3L	WASHER

GENERAL NOTES:

- MATERIAL: MAKE D2750-1/-2/-3/-4 FROM D2600-3 EXTRUSION (INITIAL LENGTH = 120.0).
- FINISH: ACID ETCH, ALODINE ASSEMBLY PER DART QSI 005 4.1 PRIOR TO INSTALLING D2739 WEB.
 STANDARD: PRIME (REF. 4.2.1.3.3) AND PAINT WHITE PER DART QSI 005 4.2
 OPTIONAL: POWDER COAT WHITE (REF. 4.3.5.1) PER DART QSI 005 4.3
 BLACK ANTI-SKID PAINT AS INDICATED TO 1.0 ABOVE SKIDTUBE CENTER-LINE PER DART 005 4.4 (OPTIONAL).
- TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- UNITS: INCHES UNLESS OTHERWISE NOTED
- BREAK SHARP EDGES: N/A
- IDENTIFICATION: N/A
- WEIGHT: D2750-041/-042/-043/-044 = 26.5 LBS
- WELD PER DART QSI 004
- INSTALL ALS4-1032-225 INSERTS AFTER FINISH AS INDICATED. DRILL 'F' SIZE HOLES ($\phi 0.297$) FOR WEARSHOE INSERTS
- FINAL CONFIGURATION SHOULD HAVE THE FOLLOWING MINIMUM MECHANICAL PROPERTIES:
 MINIMUM YIELD TENSILE STRENGTH = 35 KSI
 MINIMUM ULTIMATE TENSILE STRENGTH = 38 KSI
- COAT ALL EXPOSED FASTENERS WITH LPS LABORATORIES "LPS PROCYON" AFTER FINAL ASSEMBLY, CLEAN EXCESS OFF
 FINISH WITH MEK DEGREASER.
- SPACER AND PLUG INSTALLED SAME AS SECTION AJ-AJ EXCEPT HORIZONTAL
- SPACER AND PLUG INSTALLED SAME AS SECTION AP-AP EXCEPT HORIZONTAL

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 WITHOUT NOTICE
 WORK ORDER

NO. 181319 MJS
 180725

RELEASED
 2013-08-13
 WD

G	CORRECTED TOLERANCE ON $\phi 0.500$ THRU HOLE: IS $+0.010/-0.000$, WAS $+0.100/-0.000$ (ZN B3-4, B2-5); ADD VIEW TO CONTROL FWD BEND ORIENTATION (ZN D-1-4/-5/-6/-7); UPDATED FINISH OPTIONS; INSIDE OF TUBE NO LONGER SPRAYED WITH LPS-3. REASON: PART13-276 AND NCR13-2757	MB	13.07.11
F	INCORPORATE DSI 9413; QTY (3) D3537-1 WAS QTY (5) (ZN C8-1); D3791-1/-3 REPLACES D3535-13/-35 (ZN C8-1); D3794-1/-3 REPLACES D3536-13/-35 (ZN B8-1); ADD D3791-1 (ZN C8-1); WEARSHOE HOLES UNDER FWD/AFT SADDLE REMOVED (8 PL). WEARSHOE HARDWARE QTY UPDATED (ZN B8-1); D3488-041/-042 HARDWARE UPDATED (ZN C1-8, 9, 10, 11); ADD NOTE 12 AND 13 (ZN AG-1); REASON: REF. NCR 08-043	PH	08.07.16
E	CHANGE TO STAINLESS STEEL WEARPLATES; ADD RUBBER GASKETS; CHANGE INSERTS; ADD D3631-1; REMOVE QTY (38) NAS1515H3L; REMOVE QTY (10) NAS1515H8L; REMOVE D2741, QTY (2) AN960C816; REMOVE QTY (2) MS21083C8	CB	07.05.17
D	ADD HOLES AND SPACERS FOR APICAL FLOATS; INCORPORATE DEO 9133/9157	PH	06.01.05
C	ADD D2750-3/D2750-4; INCORPORATE D2738 AND D2740	CP	98.11.18
B	CHANGE MS24694-S293 TO AN8-16A	CP	98.09.01
A	NEW ISSUE	DS	98.04.16
REV.	DESCRIPTION	BY	DATE
DESIGN	MM		
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	13.07.11		

DART AEROSPACE USA, INC.

KENT, WA

DRAWING NO.
D2750

REV. G
SHEET 1 OF 11

TITLE
350 SKIDTUBE ASSEMBLY

SCALE
NTS

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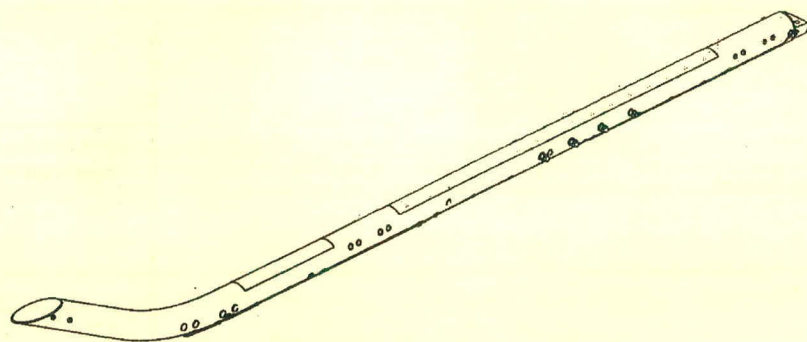


WORK ORDER NON-CONFORMANCE / UPDATE

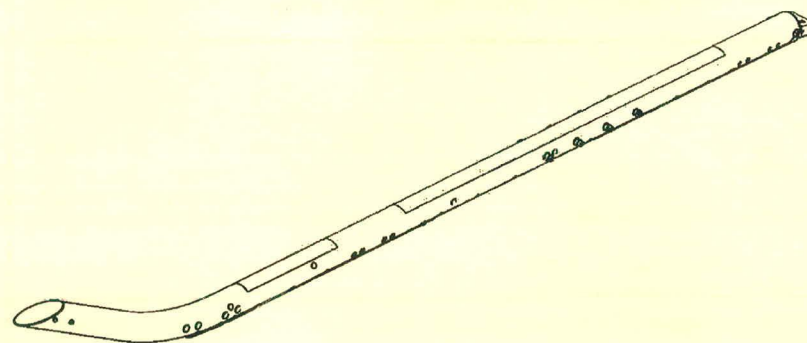
QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width: 100%; border: none;"> <tr> <td style="width: 15%;">Skid-tube ☐</td> <td style="width: 15%;">Cross tube ☐</td> <td style="width: 15%;">Water Jet ☐</td> <td style="width: 15%;">Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>				Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐																																							
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OTHER : ☐																																																											



D2750-041 350 SKIDTUBE ASSEMBLY, LH



D2750-042 350 SKIDTUBE ASSEMBLY, RH

RELEASED
2013-08-13
MD

DESIGN	MM	DART AEROSPACE USA, INC.	
DRAWN		KENT, WA	
CHECKED		DRAWING NO. D2750	REV. G
MFG. APPR.		TITLE	SHEET 2 OF 11
APPROVED		350 SKIDTUBE ASSEMBLY	SCALE
DE APPR.			NTS
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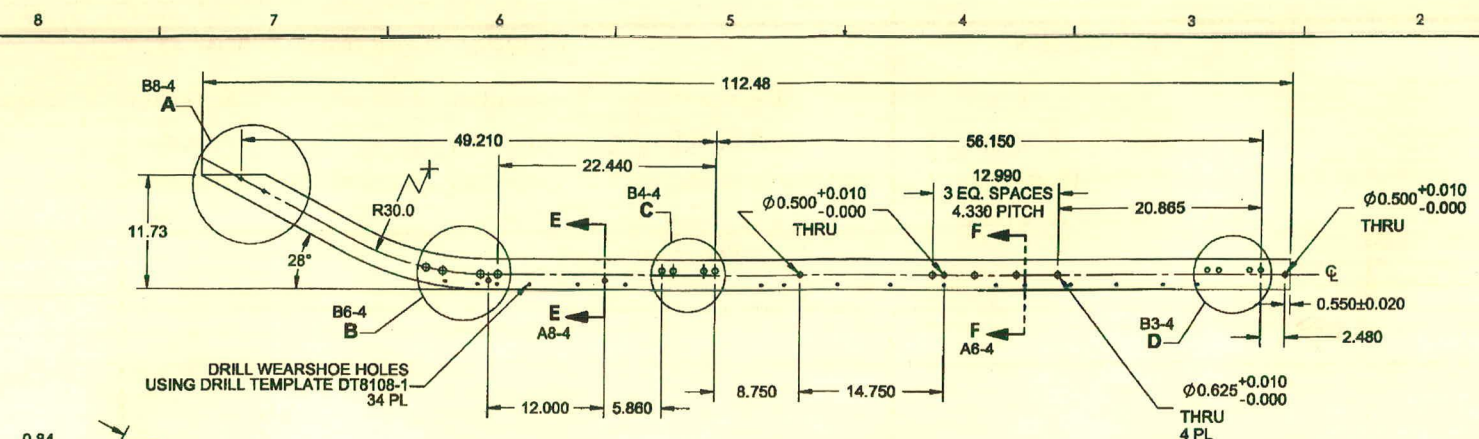


WORK ORDER NON-CONFORMANCE / UPDATE

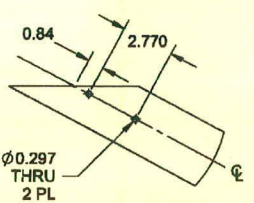
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Work Order update only ☐

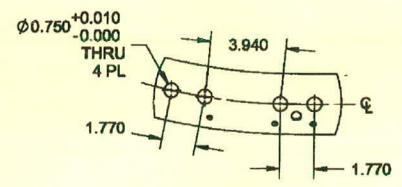
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Date :		Step #:		QTY Effective :			MRB (QSI042) Approval		
Description Work Order Deviation				Disposition				Completed By	
								Lead hand / Supervisor Approval Verification	
								QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
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Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____							
Misidentified ☐	Past Due ☐								



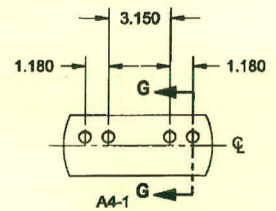
D2750-1 LH SKIDTUBE



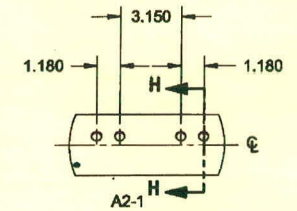
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SCALE 2X



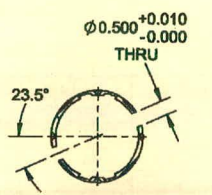
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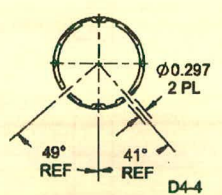
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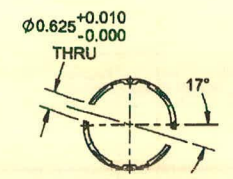
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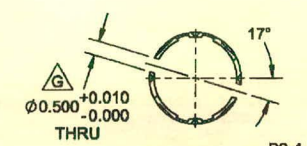
SECTION E-E
SCALE 3X, 2 PL



SECTION F-F
SCALE 3X, 17 PL



SECTION G-G
SCALE 3X, 4 PL



SECTION H-H
SCALE 3X, 4 PL



**MAX ALLOWABLE
TWIST ON FWD BEND
(VIEWED LOOKING FWD)**

RELEASED
2013-08-13
Red

DESIGN	MM	DART AEROSPACE USA, INC.	
DRAWN		KENT, WA	
CHECKED		DRAWING NO.	REV. G
MFG. APPR.		D2750	SHEET 4 OF 11
APPROVED		TITLE	SCALE
DE APPR.		350 SKIDTUBE ASSEMBLY	
DATE	13.07.11	NTS	

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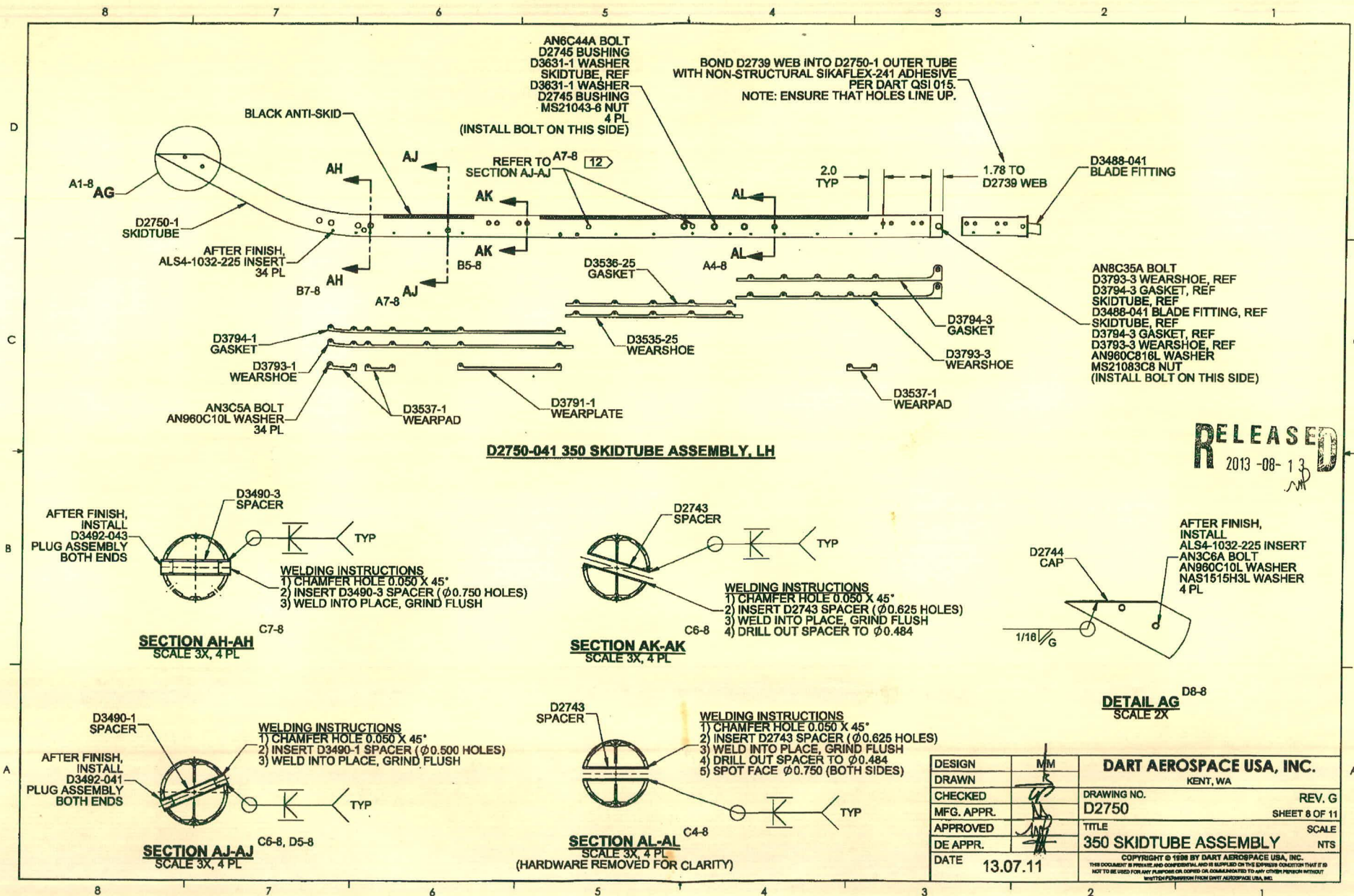
DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

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DART

DESIGN PH	DRAWN BY PH	DART AEROSPACE USA, INC. PORT HADLOCK, WA	
CHECKED CP	APPROVED [Signature]	DRAWING NO. DSI 9343	REV. A SHEET 1 OF 1
DATE 06.07.12	TITLE D350-636-011/-012 SPACER		SCALE NTS
A	06.07.12	NEW ISSUE	

DART SERVICE INSTRUCTION

TO AMEND DRAWING IIN-D350-636 REV. D

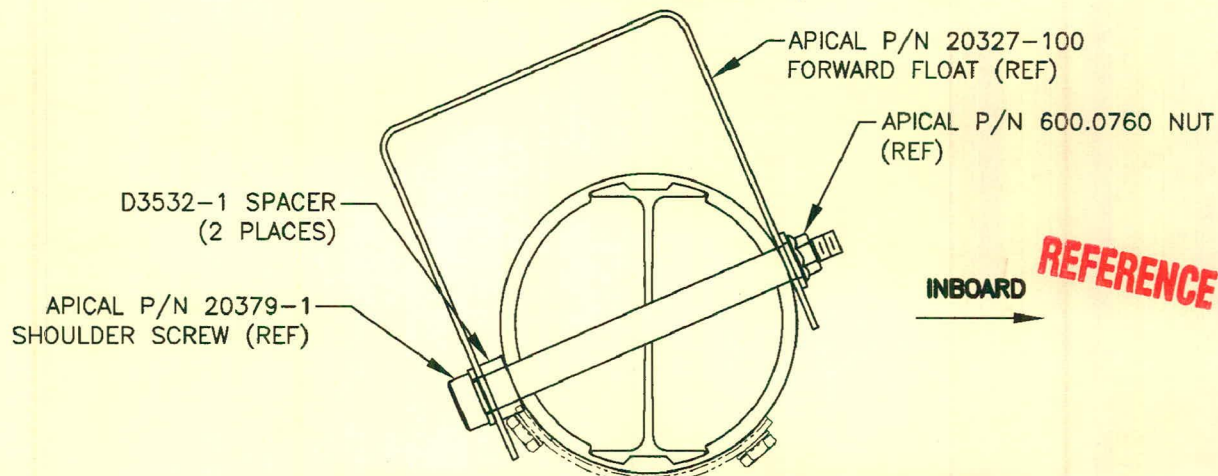
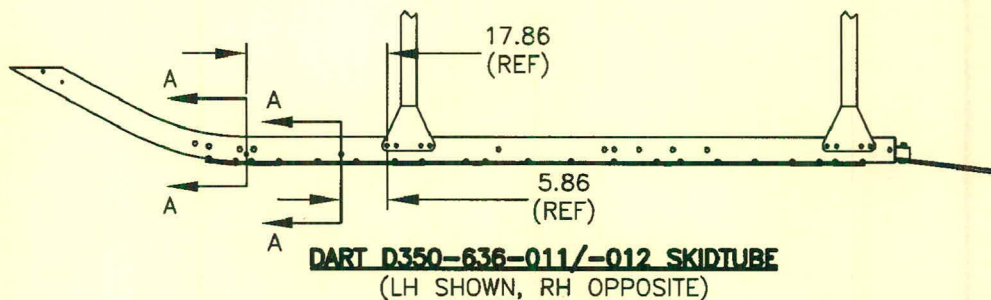
REF. FAA STC: SR00646SE

REF. CANADIAN STC: SH99-7

WHEN INSTALLING THE APICAL P/N 20327-100 FWD FLOATS ONTO THE DART D350-636-011/-012 SKIDTUBES, INSTALL THE DART D3532-1 SPACER AS SHOWN IN SECTION A-A TO ALLOW CLEARANCE FROM THE FWD WEARPLATES.

ADD THE FOLLOWING PARTS TO THE PARTS LIST ON PAGE 10 AND 11 OF IIN-D350-636 REV D:

Item	Qty -011	Qty -012	Qty -103	Qty -104	Part Number	Description
	X				D350-636-011	SKIDTUBE INSTALLATION, LH, STD AERAZUR/APICAL CYLINDRICAL FLOAT COMPATIBLE
		X			D350-636-012	SKIDTUBE INSTALLATION, RH, STD AERAZUR/APICAL CYLINDRICAL FLOAT COMPATIBLE
			X		D350-636-103	APICAL FLOAT CONVERSION KIT, LH
				X	D350-636-104	APICAL FLOAT CONVERSION KIT, RH
50	2	2	2	2	D3532-1	SPACER



SECTION A-A: DART D350-636-011/-012 SKIDTUBE
(LH SHOWN, RH OPPOSITE)

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REFERENCE 201 A

6.0 PARTS LIST

(D350-636-011/-012/-013/-014 SKIDTUBES AT CHANGE 004 OR LATER)

Item	Qty -011	Qty -012	Qty -013	Qty -014	Qty -045	Part Number	Description
	X					D350-636-011	SKIDTUBE INSTALLATION, LH, STD AERAZUR/APICAL CYLINDRICAL FLOAT COMPATIBLE
		X				D350-636-012	SKIDTUBE INSTALLATION, RH, STD AERAZUR/APICAL CYLINDRICAL FLOAT COMPATIBLE
			X			D350-636-013	SKIDTUBE INSTALLATION, LH AIRCRAUSER/ APICAL TRI-BAG FLOAT COMPATIBLE
				X		D350-636-014	SKIDTUBE INSTALLATION, RH AIRCRAUSER/ APICAL TRI-BAG FLOAT COMPATIBLE
					X	D350-636-045	WEARSHOE KIT
1	1					D2750-041	SKIDTUBE ASSEMBLY, LH
1		1				D2750-042	SKIDTUBE ASSEMBLY, RH
1			1			D2750-043	SKIDTUBE ASSEMBLY, LH
1				1		D2750-044	SKIDTUBE ASSEMBLY, RH
*1	1					D2750-1	SKIDTUBE WELDMENT, LH
*1		1				D2750-2	SKIDTUBE WELDMENT, RH
*1			1			D2750-3	SKIDTUBE WELDMENT, LH
*1				1		D2750-4	SKIDTUBE WELDMENT, RH
**2	8	8	8	8		350A41-1027-20	SCREW
**3	8	8	8	8		23119AG120LE	WASHER
**4	8	8	8	8		22541N120	NUT
*5	1	1	1	1		AN8C35A	BOLT
*6A	1	1	1	1		AN960C816L	WASHER
*7	1	1	1	1		MS21083C8	NUT
*8	1		1			D3488-041	BLADE FITTING, LH
*8		1		1		D3488-042	BLADE FITTING, RH
9	1	1	1	1		D2741	BLADE
10	2	2	2	2		AN8C21A	BOLT
11	2	2	2	2		AN960JD816	WASHER (OR NAS1149D0863J)
12	2	2	2	2		MS21083C8	NUT
*14	4	4	4	4		AN6C44A	BOLT
*15	8	8	8	8		D2745	BUSHING
*16	4	4	4	4		MS21043-6	NUT
*17	8	8	8	8		D3631-1	WASHER
*18	4	4	4	4		ALS4-1032-225	INSERT
*19	4	4	4	4		AN3C6A	BOLT
*20A	4	4	4	4		AN960C10L	WASHER
*20B	4	4	4	4		NAS1515H3L	WASHER

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Revision: J

Date: 13.03.01

5.0 PARTS LIST

(D350-636-011/-012/-013/-014 SKIDTUBES AT CHANGE 003)

Item	Qty -011	Qty -012	Qty -013	Qty -014	Qty -043	Part Number	Description
	X					D350-636-011	SKIDTUBE INSTALLATION, LH, STD AERAZUR/APICAL CYLINDRICAL FLOAT COMPATIBLE
		X				D350-636-012	SKIDTUBE INSTALLATION, RH, STD AERAZUR/APICAL CYLINDRICAL FLOAT COMPATIBLE
			X			D350-636-013	SKIDTUBE INSTALLATION, LH AIRCRAUSER/ APICAL TRI-BAG FLOAT COMPATIBLE
				X		D350-636-014	SKIDTUBE INSTALLATION, RH AIRCRAUSER/ APICAL TRI-BAG FLOAT COMPATIBLE
					X	D350-636-043	WEARSHOE KIT (REPLACES -041 KIT)
1	1					D2750-041	SKIDTUBE ASSEMBLY, LH
1		1				D2750-042	SKIDTUBE ASSEMBLY, RH
1			1			D2750-043	SKIDTUBE ASSEMBLY, LH
1				1		D2750-044	SKIDTUBE ASSEMBLY, RH
*1	1					D2750-1	SKIDTUBE WELDMENT, LH
*1		1				D2750-2	SKIDTUBE WELDMENT, RH
*1			1			D2750-3	SKIDTUBE WELDMENT, LH
*1				1		D2750-4	SKIDTUBE WELDMENT, RH
**2	8	8	8	8		350A41-1027-20	SCREW
**3	8	8	8	8		23119AG120LE	WASHER
**4	8	8	8	8		22541N120	NUT
*5	1	1	1	1		AN8C35A	BOLT (REPLACES AN8-35A)
*6A	2	2	2	2		AN960C816L	WASHER (REPLACES AN960JD816)
*6B	2	2	2	2		NAS1515H8L	WASHER
*7	1	1	1	1		MS21083C8	NUT (REPLACES MS21083N8)
*8	1		1			D3488-041	BLADE FITTING, LH (REPLACES D2742-1)
*8		1		1		D3488-042	BLADE FITTING, RH (REPLACES D2742-2)
9	1	1	1	1		D2741	BLADE
10	2	2	2	2		AN8C21A	BOLT (REPLACES AN8-16A)
11A	2	2	2	2		AN960C816L	WASHER (REPLACES AN960JD816)
11B	2	2	2	2		D3672-13	WASHER
12	2	2	2	2		MS21083C8	NUT (REPLACES MS21083N8)
*13	4	4	4	4		ALS4-1032-225	INSERT
*14	4	4	4	4		AN6C44A	BOLT (REPLACES AN6-44A)
*15	8	8	8	8		D2745	BUSHING
*16	4	4	4	4		MS21043-6	NUT (REPLACES MS21042L6)
*17	8	8	8	8		D3631-1	WASHER (REPLACES NAS1515H8L)
*18	4	4	4	4		ALS4-1032-225	INSERT (REPLACES NAS1330S3KB166)
*19	4	4	4	4		AN3C6A	BOLT (REPLACES AN3-6A)

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(CONTINUED FROM PREVIOUS PAGE)

Item	Qty -011	Qty -012	Qty -013	Qty -014	Qty -043	Part Number	Description
*20A	4	4	4	4		AN960C10L	WASHER (REPLACES AN960JD10)
*20B	4	4	4	4		NAS1515H3L	WASHER (REPLACES AN960JD10)
*22	5	5	5	5	5	D3537-1	WEARPAD (REPLACES D2648-3)
*23A	1	1	1	1	1	D3535-13	WEARSHOE (REPLACES D2656-13)
*23B	1	1	1	1	1	D3536-13	GASKET
*24A	1	1	1	1	1	D3535-25	WEARSHOE (REPLACES D2746)
*24B	1	1	1	1	1	D3536-25	GASKET
*25A	1	1	1	1	1	D3535-35	WEARSHOE (REPLACES D2656-35)
*25B	1	1	1	1	1	D3536-35	GASKET
*26A	38	38	38	38	38	AN3C5A	BOLT (REPLACES AN3-5A)
*26B	4	4	4	4	4	AN3C7A	BOLT (REPLACES AN3-7A)
*27	42	42	42	42	42	AN960C10L	WASHER (REPLACES AN960JD10)
*28	38	38	38	38		ALS4-1032-225	INSERT (REPLACES NAS1330S3KB166)
*30	8	8	8	8		D3492-041	PLUG ASSEMBLY
*31	8	8				D3492-043	PLUG ASSEMBLY
*32			8	8		D3492-045	PLUG ASSEMBLY
***43	2	2	2	2		D3493-1	WASHER
50	2	2				D3532-1	SPACER

* PART OF D2750-041/-042 OR D2750-043/-044 ASSEMBLY

** TO BE SUPPLIED BY CUSTOMER

*** ONLY INSTALLED IF INSTALLING AN APICAL FLOAT SYSTEM

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